

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 2

Hand Finishing

8

8x8 m/l 12/01/04

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 76804

76804

Page 3

Monday, November 21, 2011 11:24:15 AM

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 2:40								
	OVENTEMPERATURE: 320								
	FINISH TIME: 3:10								
160	QC3- Inspect Part Finish	0.00							
160									
QC									
Quality Control	Memo	0.00							
170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging									
Packaging	Memo	0.00							

8X/ M/ 12/04/05

8 12-1-6

12/16/10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 11:24:19 AM

Page 1

Work Order ID: 76804

76804

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 11/21/2011

Required Date: 12/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.06.22Removed P/O for powder coatEC
IPP Rev:D As per Rev D 07-03-19 JLM IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	152.0000	1	8			
										**		B.O	11/12/27

D6101-001

Saddle Billet

Location	Loc Qty	Loc Code
MAT040	152	
66965	1	
69677	2	
73774	60	
74648	21	
74679	68	
→ 76836		

8.0

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	76804
Description: 206 Saddle, Inboard, Left side	Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim _r	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.136	0.137	0.136	0.136		
B	0.100	0.140		0.126	0.126	0.126	0.126		
C	1.125	1.145		1.136	1.137	1.136	1.136		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		0.249	0.249	0.249	0.249		
F	1.313	1.343		1.323	1.323	1.323	1.323		
G	0.210	0.230		0.220	0.220	0.220	0.220		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.577	1.577	1.577	1.576		
K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.797	0.797	0.797		
W	0.540	0.560		0.551	0.551	0.551	0.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.922	0.922	0.922	0.922		
AA	0.490	0.510		0.501	0.502	0.500	0.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: B.A	Audited by: JL
Date: 11/12/28	Date: 12-01-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76804
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

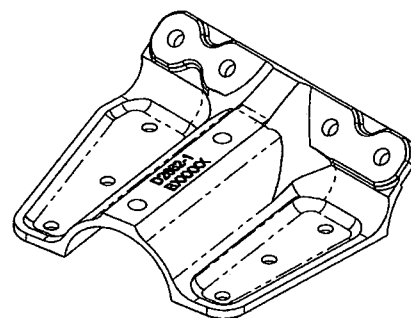
Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		0.136	0.137	0.137	0.136		
B	0.100	0.140		0.126	0.125	0.126	0.126		
C	1.125	1.145		1.136	1.136	1.137	1.137		
D	0.615	0.685		0.685	0.685	0.685	0.685		
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K	0.235	0.240		0.237	0.237	0.237	0.237		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.999	0.999	0.999	0.999		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
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Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
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V	0.787	0.807		0.797	0.797	0.797	0.797		
W	0.540	0.560		0.551	0.551	0.551	0.551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
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AA	0.490	0.510		0.500	0.500	0.500	0.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

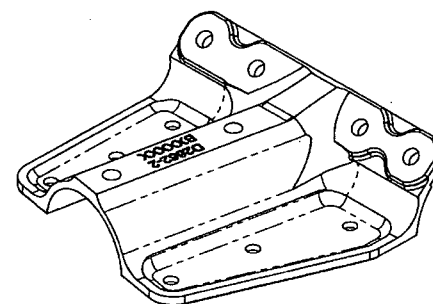
Measured by: M.A
Date: 11/12/20

Audited by: SL
Date: 12-01-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

STANDARD
F. 100-1
ENGINE
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 74804

01/11/21

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	00	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	00		
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	2/11	D2662	SHEET 1 OF 5
APPROVED	2/11	TITLE	SCALE
DE APPR.	2/11	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

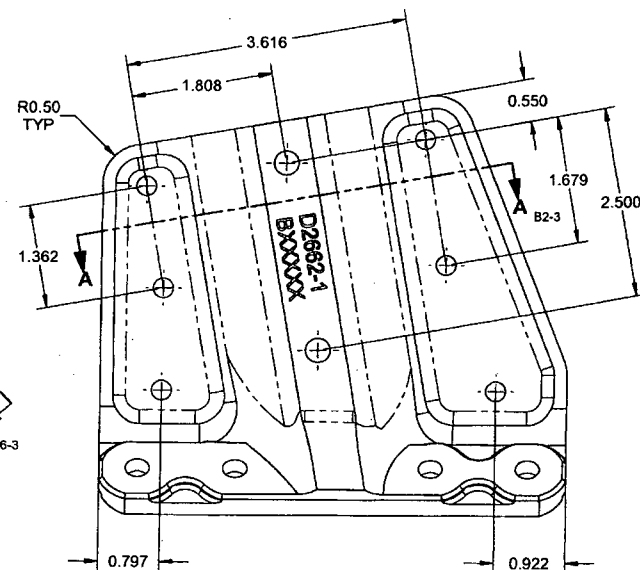
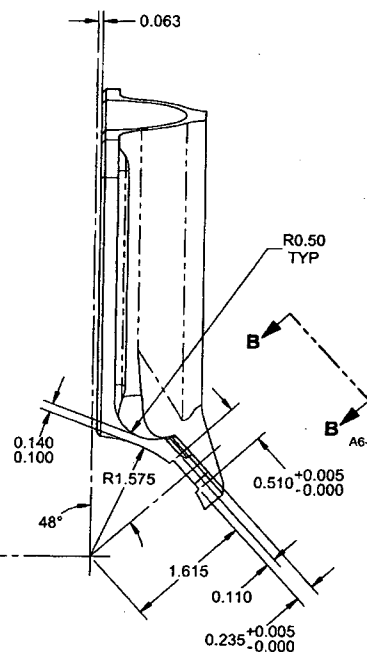
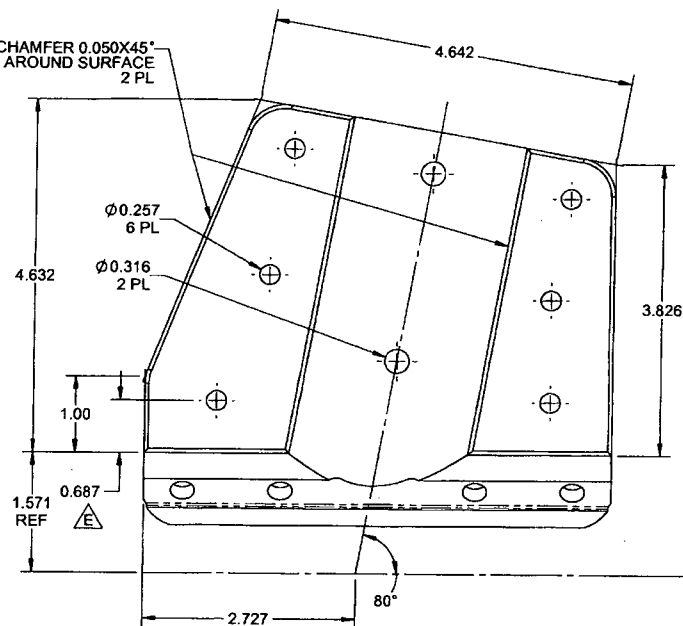
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CHAMFER 0.050X45°
AROUND SURFACE
2 PL



D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	GP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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RELEASED
2011-11-16

748061

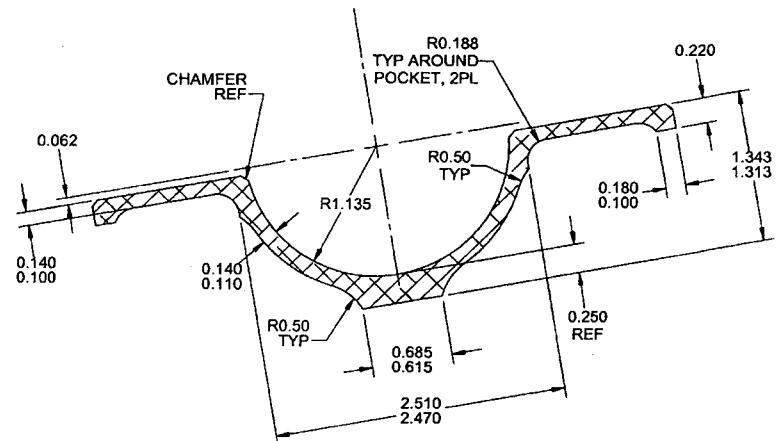
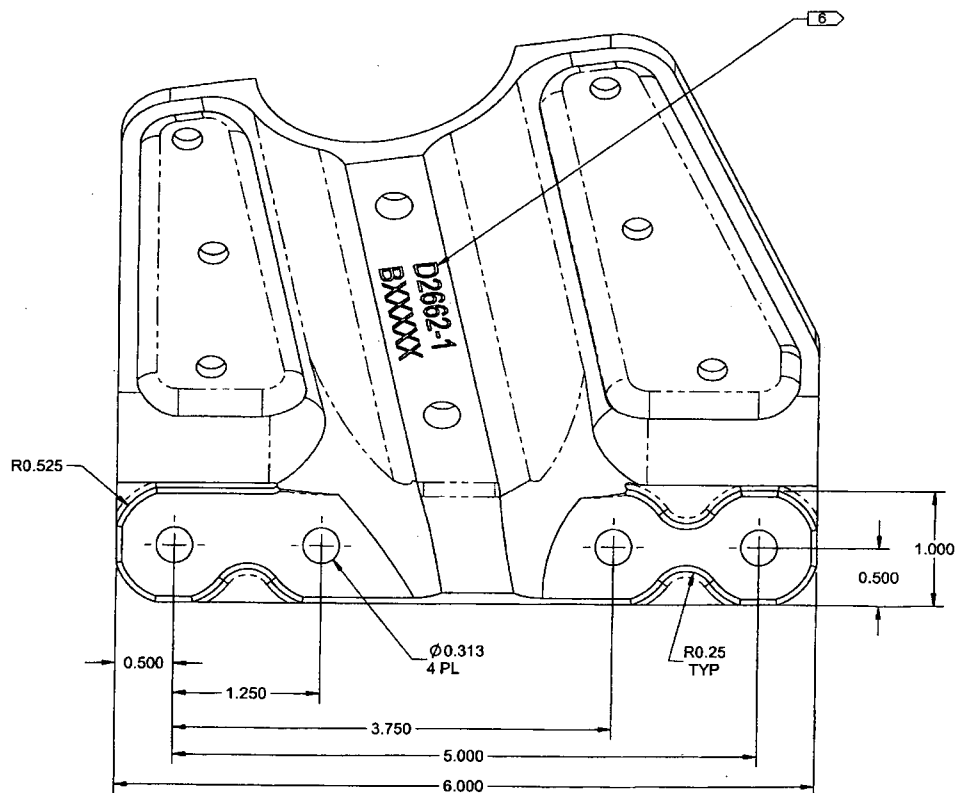
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NOTE: Date & initial all entries



VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16

76804

DESIGN	gp	DART AEROSPACE USA, INC.	
DRAWN	gp	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	SM	D2662	SHEET 3 OF 5
APPROVED	SM	TITLE	SCALE
DE APPR.	SM	SADDLE, INSIDE	NTS
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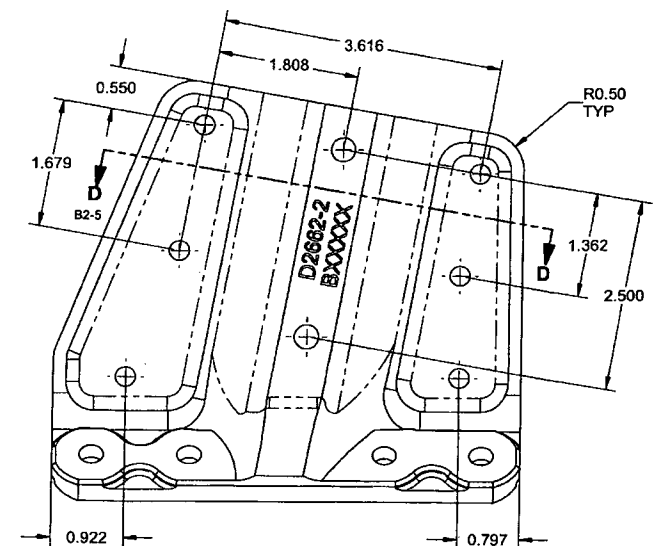
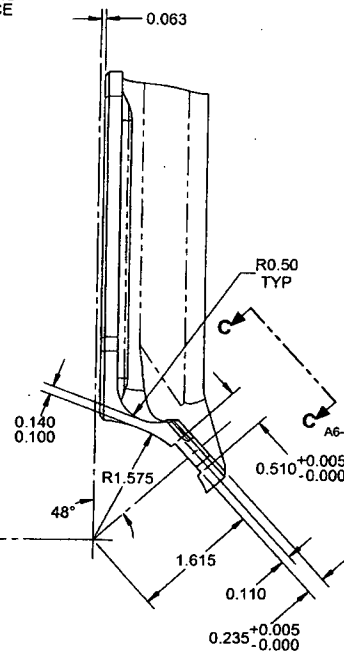
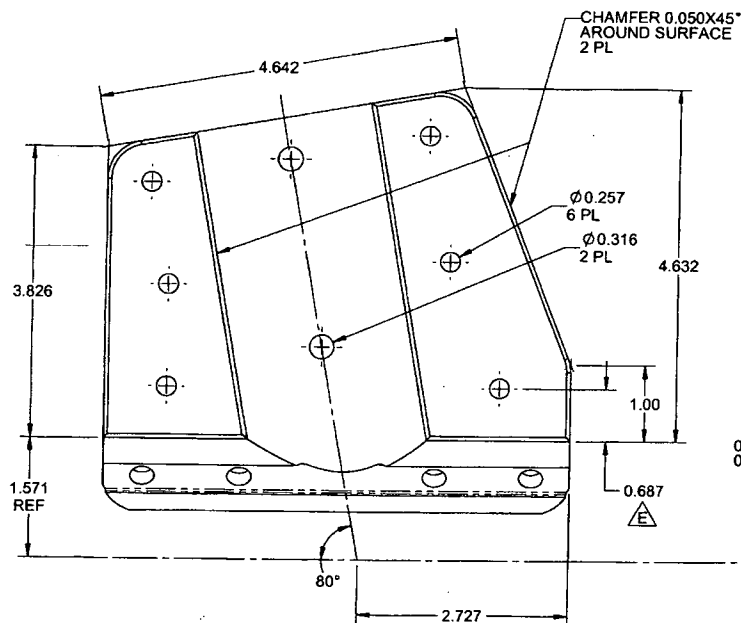
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RELEASED
2011-11-16

D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
- 2) FINISH: MAKE FROM D6101-001 SADDLE BILLET
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
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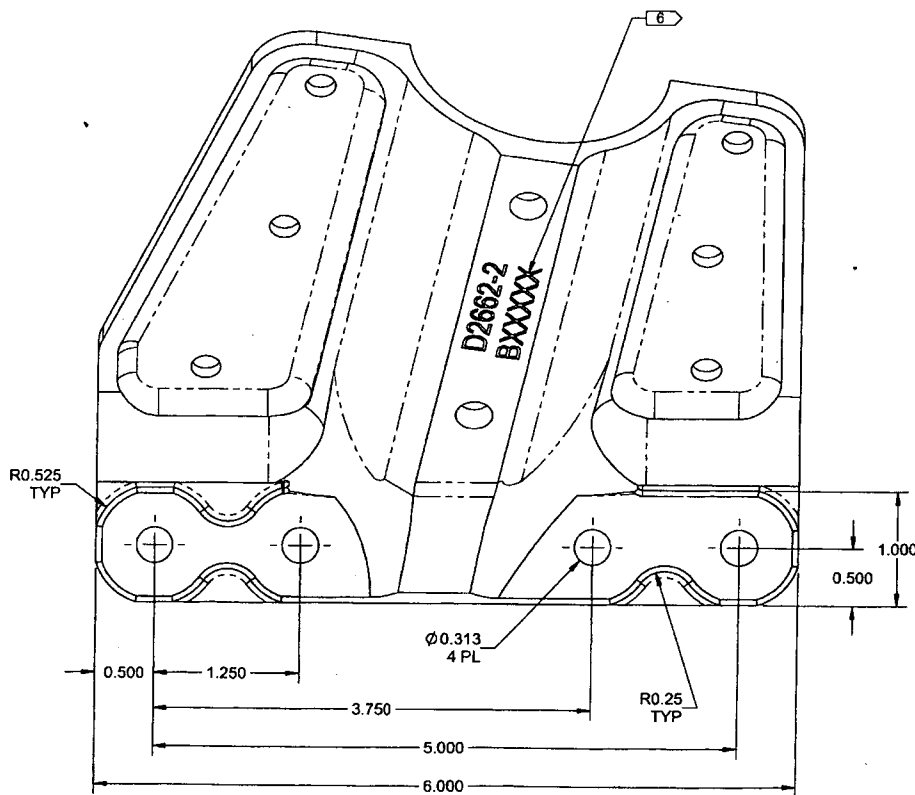
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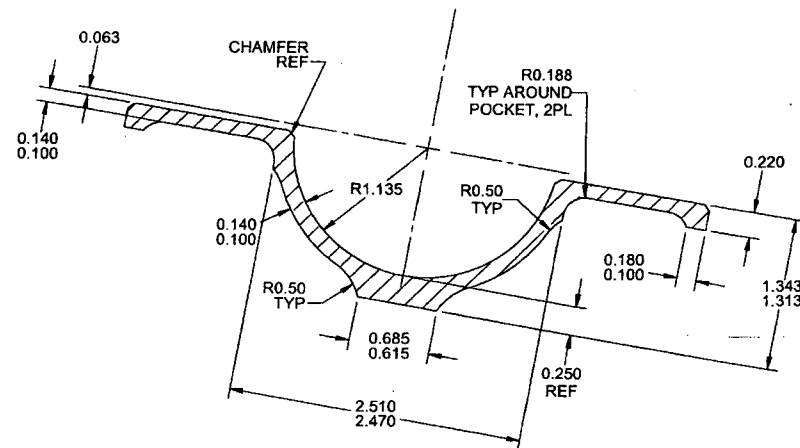
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VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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